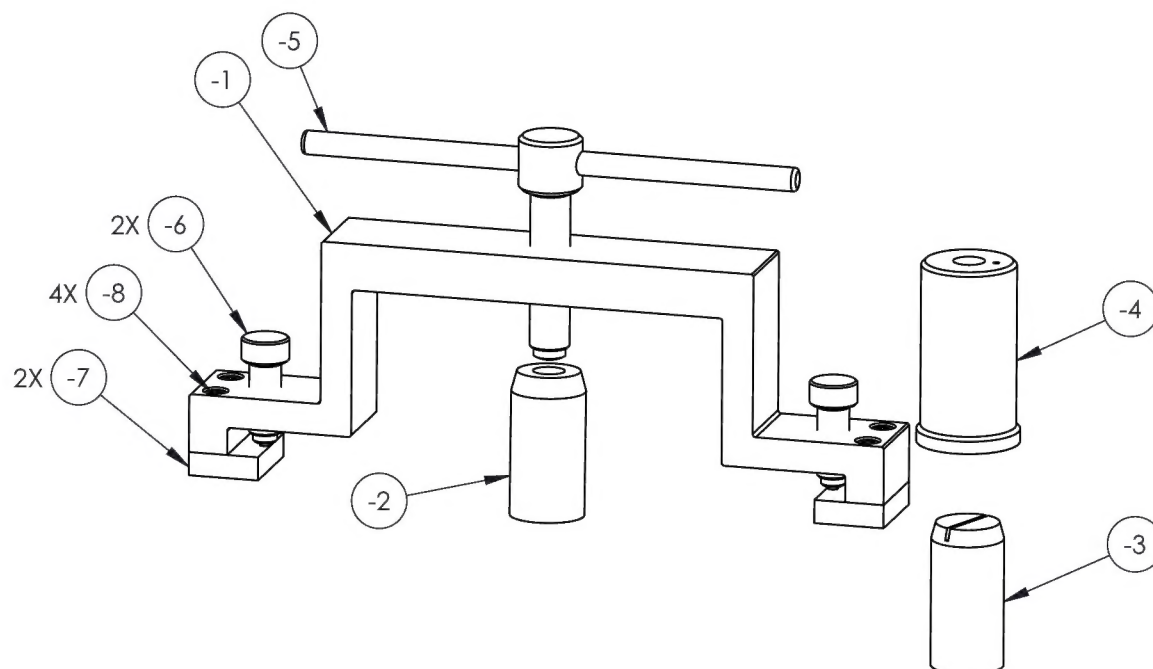



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0231	REDRAWN FROM TATTERED HARD TO READ DRAWING. -1 USE OPTIONAL ON PIECE CONSTRUCTION.	12/30/2014	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PRESS	1018		2
			-2	1	DRIFT	4140/4142		3
			-3	1	GUIDE	4140/4142		4
			-4	1	SLEEVE	4140-4142		5
X			-5	1	SCREW ASSEMBLY			6
1			-5A		THREADED BOLT	4130		7
1			-5B		HANDLE	1018/1020		8
			-6	2	SCREW	1018/1020		9
			-7	2	CLAMP PRESS	1018/1020		10
		B/O	-8	4	SOCKET HEAD CAP SCREW	STEEL	1/4-20 UNC X 1 (MCMaster-CARR #92562A271)	1
ASSY -5	ASSY -1							



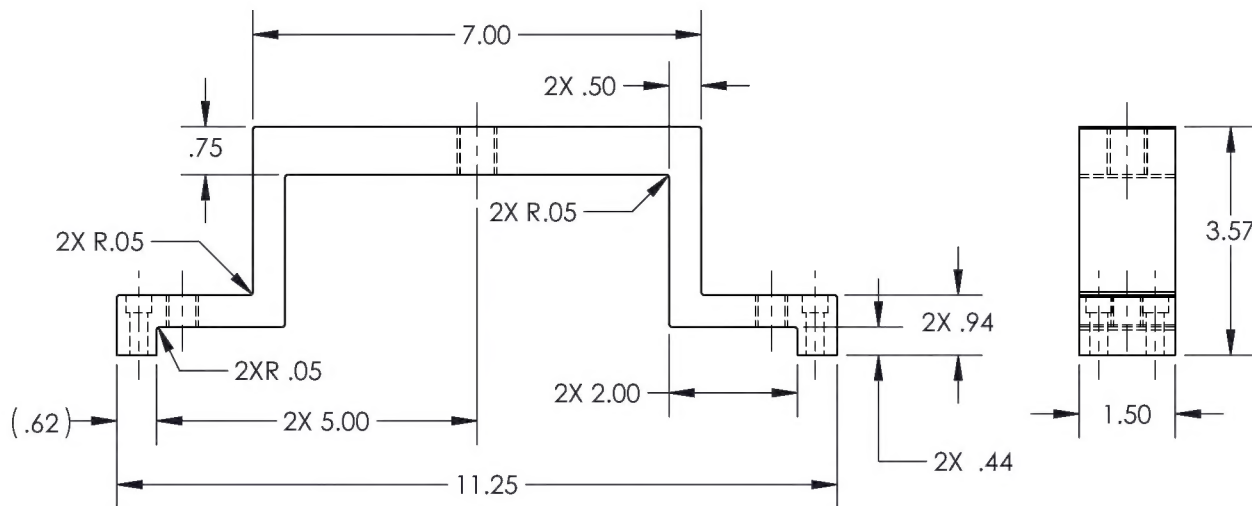
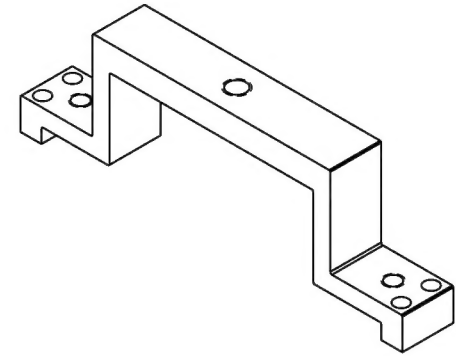
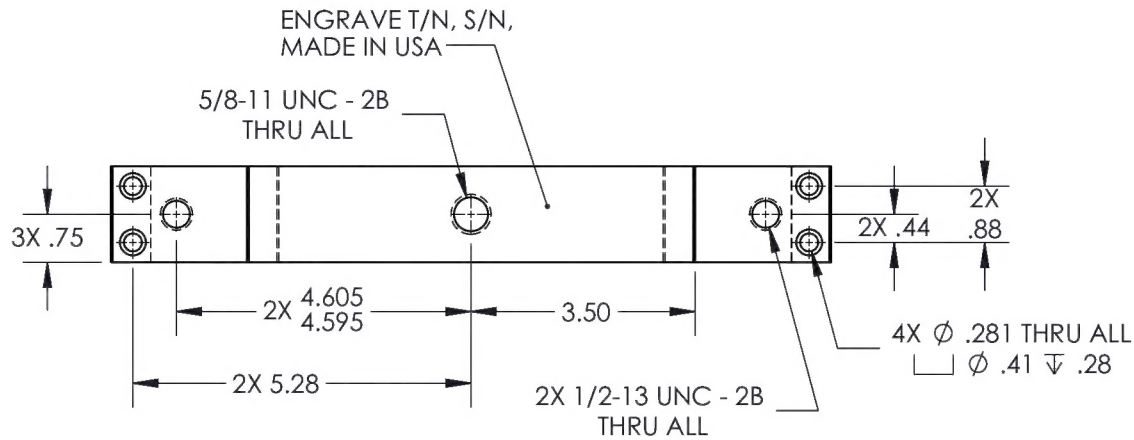
DART

AEROSPACE

TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543	REV 1
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .02 ANGLES ± 1°	APPROVED <i>J. Gilbert</i> HEAT TREAT FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL ENGINE MODELS 250 SERIES
SCALE 1:3	DATE 12/29/2014
SHEET 1 OF 10	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

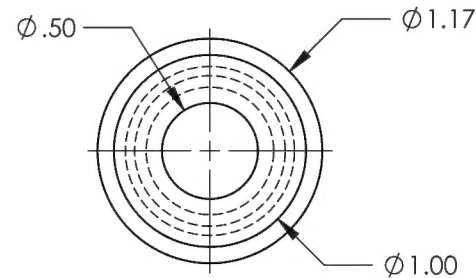
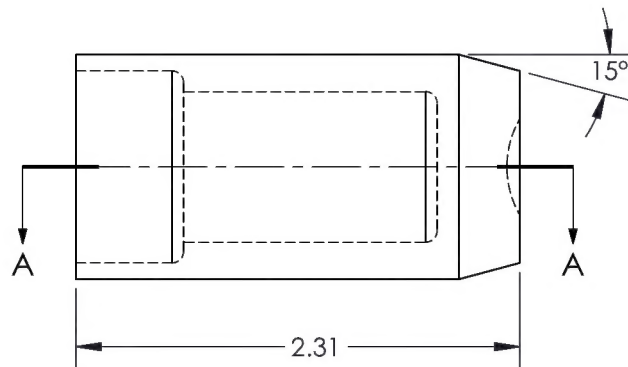
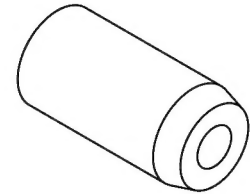
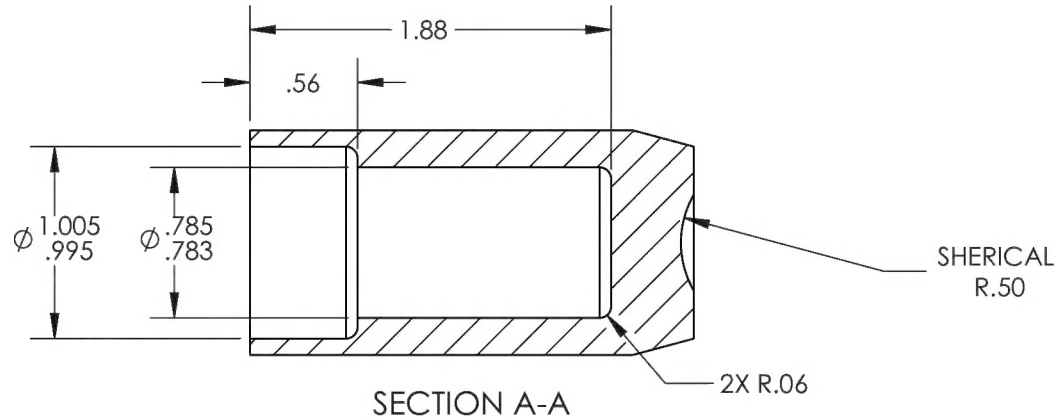


(-1)
PRESS

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-1
MAT'L 1018	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX \pm .010 .XX \pm .02	HEAT TREAT FINISH CAD PLATE YELLOW
FRACTIONS \pm 1/8 ANGLES \pm 1°	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	ENGINE MODELS 250 SERIES
SCALE 1:3	DATE 1/9/2015
SHEET 2 OF 10	

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REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

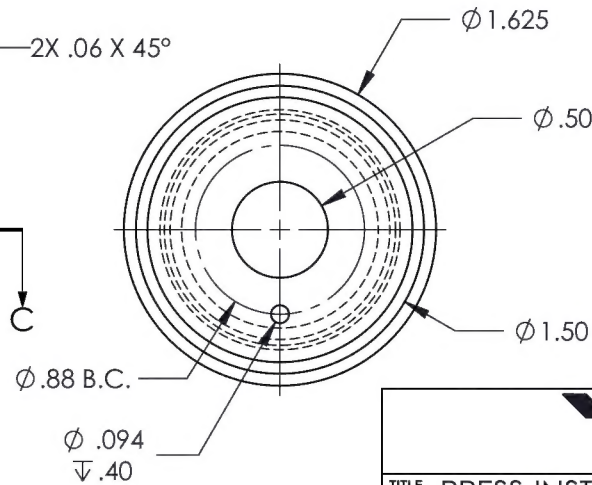
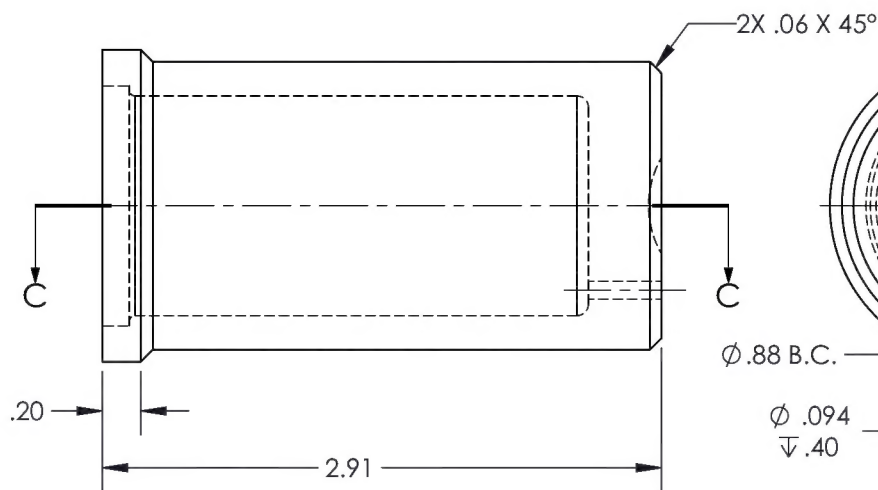
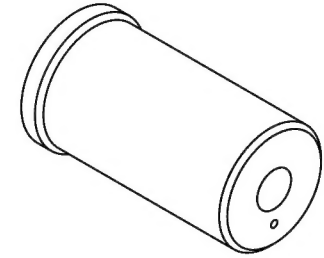
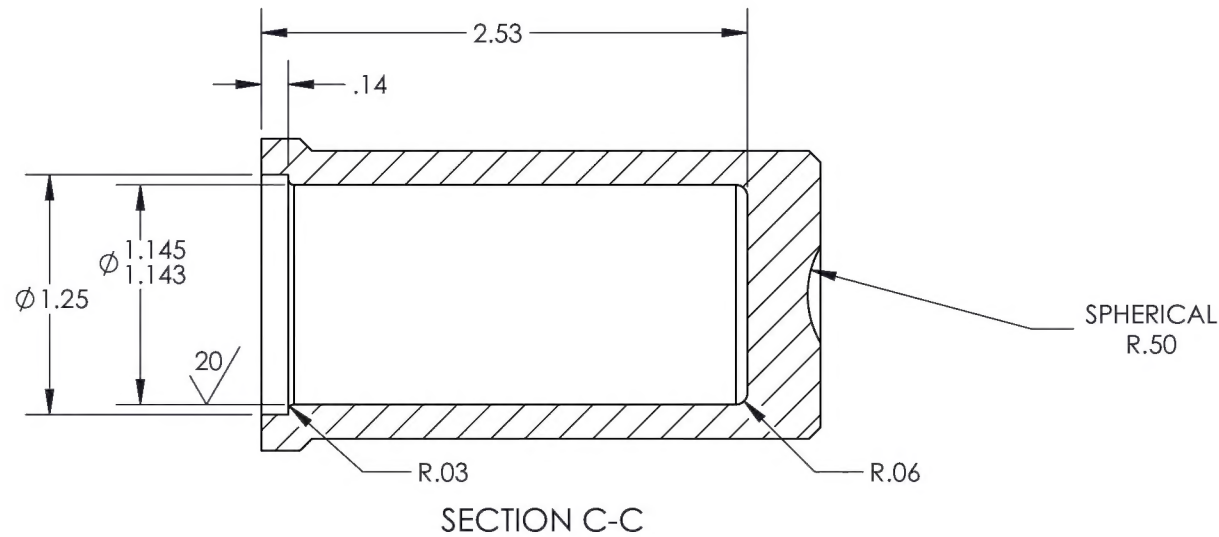


(-2)
DRIFT

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543-2	REV 1
MAT'L 4140/4142	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J. Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT RC 36-40
.XX ± .02 ANGLES ± 1°	TREAT CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	ENGINE MODELS 250 SERIES
DATE 12/29/2014	SHEET 3 OF 10

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REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED

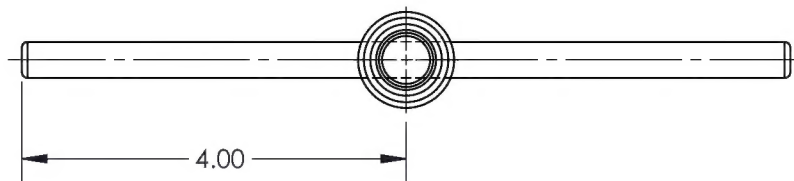
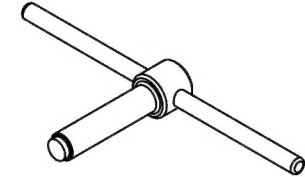
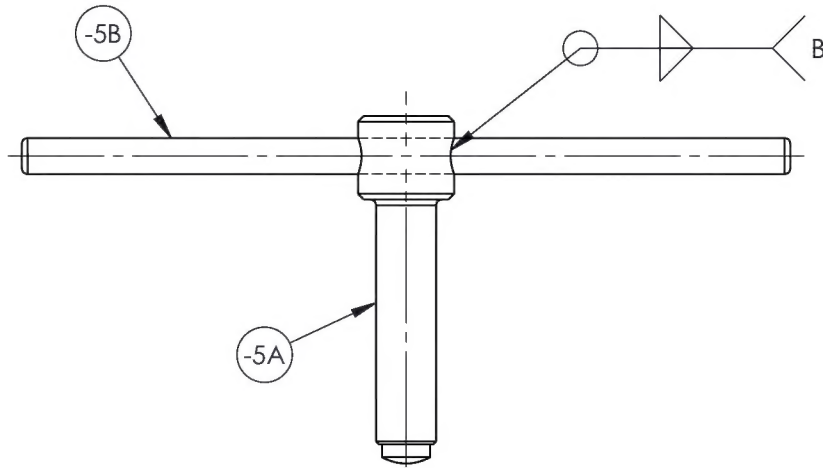


(-4)
SLEEVE

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543-4	REV 1
MAT'L 4140-4142	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J. Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 32-36
.XX ± .02 ANGLES ± 1°	FINISH BLACK OXIDE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	ENGINE MODELS 250 SERIES
SCALE 1:1	DATE 12/29/2014
	SHEET 5 OF 10

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED

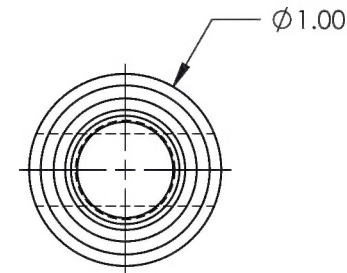
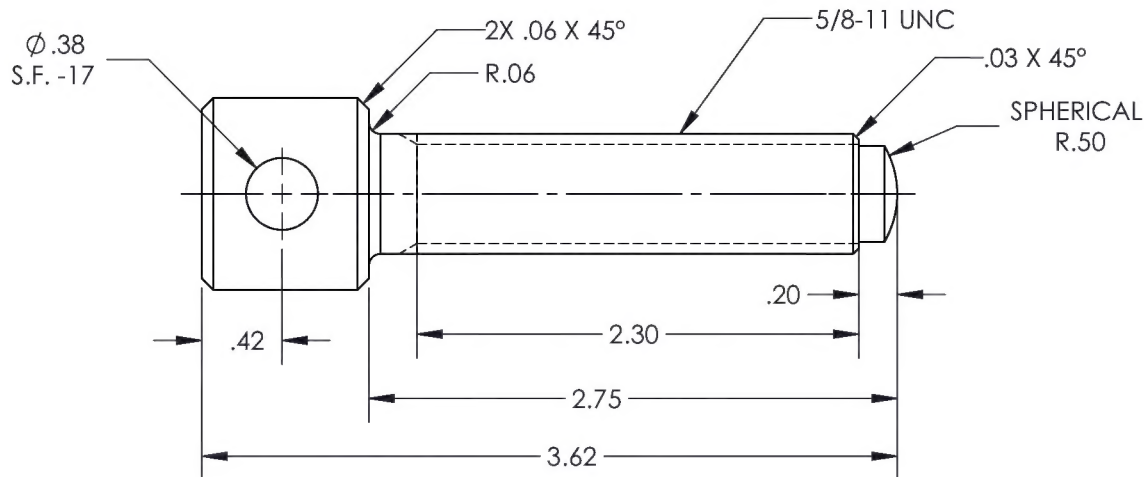
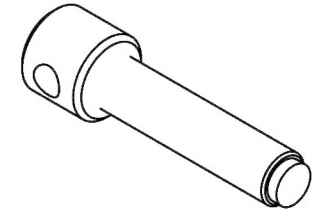


(-5)
SCREW ASSEMBLY

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543-5	REV 1
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 .XX ± .02	HEAT TREAT FINISH CAD PLATE YELLOW
FRACTIONS ± 1/8 ANGLES ± 1°	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	ENGINE MODELS 250 SERIES
SCALE 1:1	DATE 12/29/2014 SHEET 6 OF 10

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



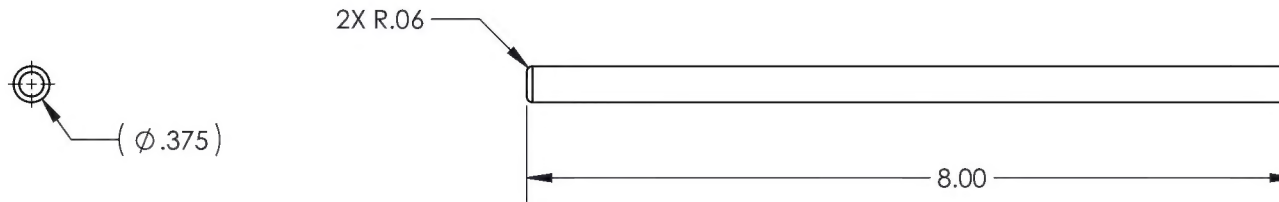
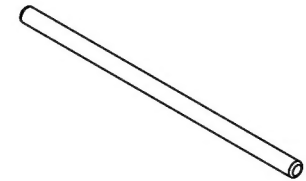
(-5A)

THREADED BOLT

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	RB6872543-5A
MAT'L 4130	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: CLOUGH
.XXX ± .010	APPROVED <i>J. Gilbert</i>
.XX ± .02	HEAT TREAT RC 32-36
FRACTIONS ± 1/8	FINISH SEE -5
ANGLES ± 1°	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	ENGINE MODELS 250 SERIES
SCALE 1:2	DATE 12/29/2014
SHEET 7 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



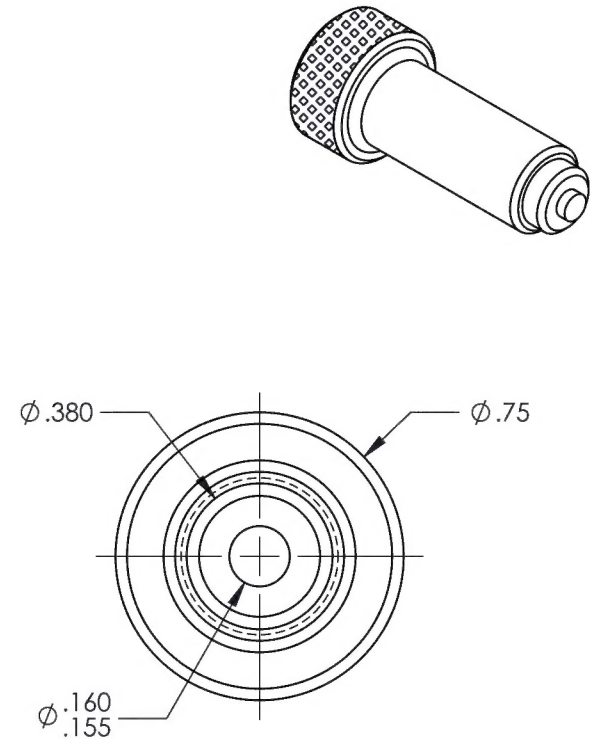
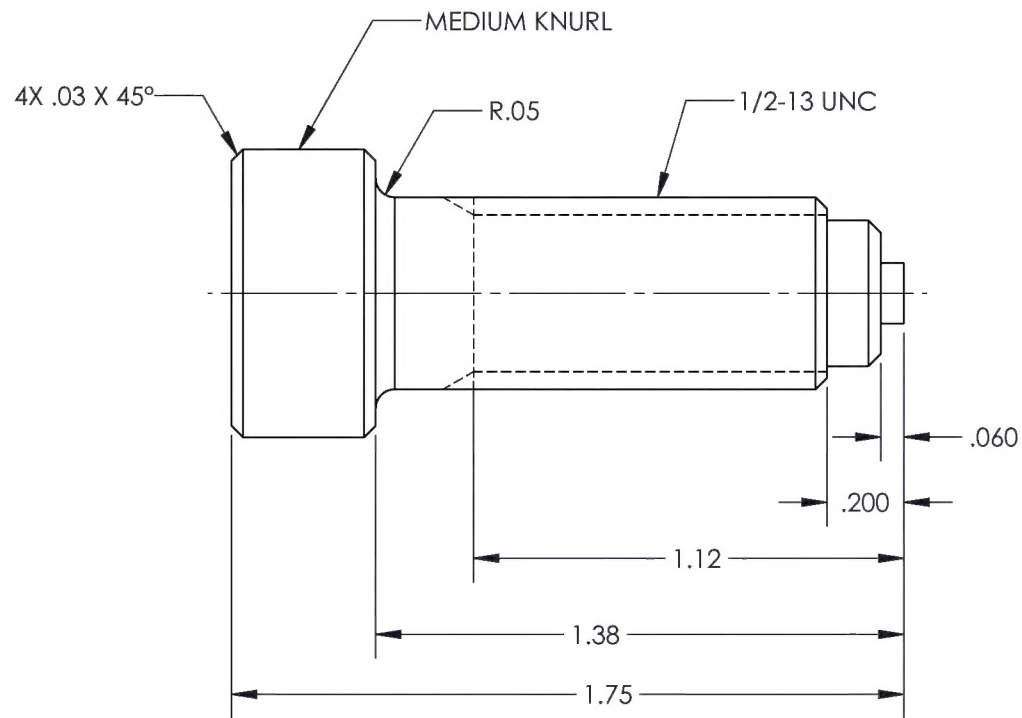
(-5B)

HANDLE

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543-5B	REV 1
MAT'L 1018/1020	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH SEE -5
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	ENGINE MODELS 250 SERIES
SCALE 1:2	DATE 12/29/2014
SHEET 8 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



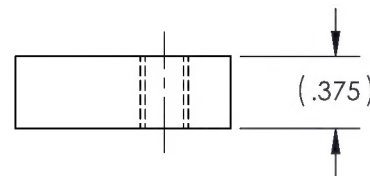
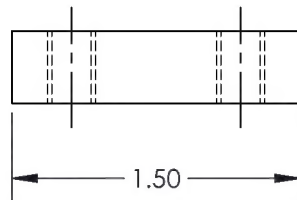
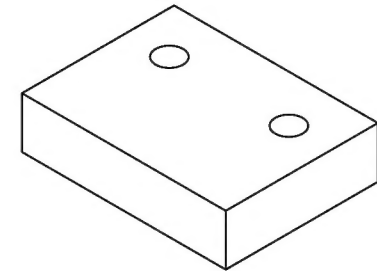
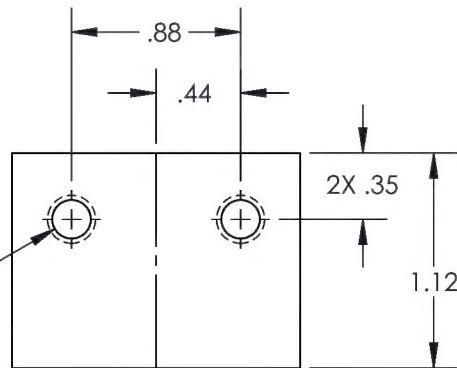
(-6)
SCREW

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO.	REV
RB6872543-6	1
MAT'L 1018/1020	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	ENGINE MODELS 250 SERIES
DATE 12/29/2014	SHEET 9 OF 10

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

2X 1/4-20 UNC - 2B
THRU



(-7)

CLAMP PRESS

DART AEROSPACE	
TITLE PRESS-INSTALLATION, POWER TURBINE REAR & GAS PRODUCER FRONT BRG.	
DWG NO. RB6872543-7	REV 1
MAT'L 1018/1020	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	ENGINE MODELS 250 SERIES
SCALE 1:1	DATE 12/29/2014
SHEET 10 OF 10	